

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130224

Friday, February 27, 2015 2:34:03 PM

130224

Page 2

Item ID: D4434-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Inboard Bracket Assembly
 Start Date: 2/27/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/27/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
140	<i>m 123480</i>								<i>H. 15-4-1</i>
Powdercoat	Memo	0.00							
Powder Coating	*** MASK NUT PLATE HOLES PER DWG ***								
	START TIME: <i>1:40</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>5:10</i>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160									
Small Fab	Memo	0.00							
Small Fab	Install rubber seals and grommets.								
	3M 1300 batch: <i>M131012</i>								

APR 07 2015

DAS
30
9-89

4

APR 09 2015

4 FF

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130224

Friday, February 27, 2015 2:34:03 PM

130224

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							DAS 38 9-89
Quality Control									APR 09 2015
180	Identify as per dwg & Stock Location: <u>ST 62200</u>	0.00							
180									
Packaging	Memo	0.00							DAS 26 9-89
Packaging									APR 14 2015
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									MLD 15-04-15 MF 15-4-15

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 130224

130224

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 2/27/2015

Required Date: 2/27/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA5 EC verified by:JLM IPP RevC 12.01.24
per REV.A DD verified by:EC IPP RevD 12.03.05 per REV.B
DD verified by:EC IPP REV:E 13.04.01 AS PER D4434 REV.C
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-1		Manufactured	No			110	Each	1.0000	1	4			
D4434-1									**				
Bracket													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST246		1	B 130609			4			
				126466		1							
D4434-9		Manufactured	No			110	Each	0.0000	1	4			
D4434-9									**				
Bracket													
D4435-041		Manufactured	No			110	Each	6.0000	1	4			
D4435-041									**				
Bracket Assembly													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST107	130884	6				2			
				122909		4							
				128397		2				2			
D4441-1		Manufactured	No				f	616.3750		1			
D4441-1									**				
Rubber Seal													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST407		383.875							
				120932		383.875				1			
				ST422		232.5							
				120932		232.5							

Cut qty 1 to 1.7"

4

FF

MAR 25 2015

FF

MAR 25 2015

FF

FF

APR 09 2015

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 130224

130224

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 2/27/2015

Required Date: 2/27/2015

Start Qty: 4.00

Required Qty: 4.00

D4441-1 Manufactured No

f

616.3750

1

D4441-1

Rubber Seal

FF

APR 09 2015

Location

Loc Qty

Loc Code

ST407

383.875

120932

383.875

1

ST422

232.5

120932

232.5

Cut qty 1 to 2.5"

D4441-1 Manufactured No

f

616.3750

8

D4441-1

Rubber Seal

FF

APR 09 2015

Location

Loc Qty

Loc Code

ST407

383.875

120932

383.875

8

ST422

232.5

120932

232.5

Cut qty 1 to 22.5"

D4440-1 Manufactured No

160

Each

30.0000

1

4

D4440-1

Grommet

FF

APR 09 2015

Location

Loc Qty

Loc Code

ST107

30

129462

30

4

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Page 3

Work Order ID: 130224

Parent Item: D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

130224

D4434-043

Start Date: 2/27/2015

Required Date: 2/27/2015

Start Qty: 4.00

Required Qty: 4.00

AN525-832R6

Purchased

No

110

Each

87.0000

3

12

AN525-832R6

Screw

**

FF

APR 09 2015

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

69

m130466

69

ST329

4

m130325

4

12

MS20426AD3-2

DAS
30
9-89

Purchased

No

110

Each

18,153.00

12

48

MS20426AD3-2

Rivet

**

FF

MAR 25 2015

Location

Loc Qty

Loc Code

Mezz

18153

1173

8873

13276

9280

40

MS20426AD3-3

Purchased

No

110

Each

5,505.000

2

8

MS20426AD3-3

RIVET

**

FF

MAR 25 2015

Location

Loc Qty

Loc Code

ST313

5505

M128754

5

M131624

5500

8

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Friday, February 27, 2015 2:34:07 PM

Page 4

Work Order ID: 130224

130224

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 2/27/2015

Required Date: 2/27/2015

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-3

Purchased

No

110

Each

2,218.000

5

20

MS20470AD4-3

Rivet - Universal Head

FF

MAR 25 2015

Location

Loc Qty

Loc Code

GA

974

2193

974

20

ST310

1244

2193

1244

MS21075L08

Purchased

No

110

Each

137.0000

7

28

MS21075L08

ANCHOR NUT

FF

MAR 25 2015

Location

Loc Qty

Loc Code

ST300

137

128429
M128635

137

28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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